

Split

Sub Nov 29

Work Order ID 153190-2

Wednesday, November 09, 2016 12:45:00 P

647.7501

153190

Page 1

Item ID: 647.7501

Revision ID:

Item Name: Lower Cutter Assembly

Start Date: 11/10/2016 Start Qty: 4.00

Required Date: 11/15/2016 Req'd Qty: 4.00

Reference:

V A Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals

Process Plan: VS

Date: 11/11/16

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7500	A

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Packaging

Memo

0.00

✓ NOV 23 2016

DAS
6
9-89

120

120

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 135385
exp. date: 04/18

2x

16/12/14

DAS
36
9-89

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

2

DAS
38
9-89

DEC 16 2016

Work Order ID 153190

Wednesday, November 09, 2016 12:45:00 P

153190

Page 2

Item ID: 647.7501

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Lower Cutter Assembly

Stop ***NS2***

Start Date: 11/10/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/15/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: SA

0.00

140

Packaging

Memo

0.01

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

2 DEC 6 2016

DEC 1 6 2016

DAS
6
9-89

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.07

Quality Control

DAS
21
9-89

DEC 1 6 2016

DEC 1 6 2016

Picklist Print

Wednesday, November 09, 2016 12:45:07 PM

Page 1

Work Order ID: 153190

153190

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7813 *647 7813* Center Plate, Lower		Manufactured	No				Each	9.0000		4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK114				9					
				147215				9					
647.7810 *647 7810* Bracket A		Manufactured	No				Each	3.0000		4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK077A				3					
				146724				3					
647.7811 *647 7811* Bracket B		Manufactured	No				Each	3.0000		4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK077A				3					
				146725				3					
646.3015 *646 3015* Blade		Manufactured	No				Each	1.0000		8			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck103				1					
				147542				1					

B 150 682

2
6

NOV 23 2016
DAG
9-89

NOV 23 2016
DAG
9-89

NOV 23 2016
DAG
9-89

NOV 23 2016
DAG
9-89

Picklist Print

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Work Order ID: 153190

Parent Item: 647.7501

Parent Item Name: Lower Cutter Assembly

153190

647 7501

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

647.7601

Manufactured No

Each 3.0000

647 7601

Lower Deflector Assembly

**

4
137076 NOV 23 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

cck065

3

148222

3

Each

3.0000

**

3
4

NOV 23 2016

DAS
6
9-89

647.7815

Manufactured No

647 7815

Fwd Bracket

Location

Loc Qty

Loc Code

CCK114

3

138151

3

Each

3.0000

**

3
4

NOV 23 2016

DAS
6
9-89

647.7814

Manufactured No

647 7814

Fwd Bracket

Location

Loc Qty

Loc Code

CCK114

3

138152

3

Each

3.0000

**

3
4

NOV 23 2016

DAS
6
9-89

647.7816

Manufactured No

647 7816

Aft Bracket

Location

Loc Qty

Loc Code

CCK114

3

138240

3

Each

4.0000

**

3
4

NOV 23 2016

DAS
6
9-89

647.7817

Manufactured No

647 7817

Aft Bracket

Location

Loc Qty

Loc Code

CCK115

4

138364

4

4

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Shop Packet Print

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Page 3

Work Order ID: 153190

Parent Item: 647.7501

Parent Item Name: Lower Cutter Assembly

153190

647 7501

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

NAS1149FN832P

Purchased

No

Each

1,519.000

104

NAS1149FN832P

Washer

**

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

1389

M133769

89

M135058

1300

ST263

130

M135603

130

Each

0.0000

12

**

135767 NOV 23 2016

DA
6
9-89

MS21042-3

MS21042L3

Purchased

No

MS21042-3

Nut

MS21042-08

MS21042L08

Purchased

No

MS21042-08

USE MS21042L08

NAS1149F0332P

Purchased

No

NAS1149F0332P

Washer

Each

2,822.000

24

**

NOV 23 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

276

m133709

276

ST260a

2000

m135948

2000

ST262

546

m135544

546

NOV 23 2016

Picklist Print

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Page 4

Work Order ID: 153190

Parent Item: 647.7501

Parent Item Name: Lower Cutter Assembly

153190
647 7501

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

MS27039-08-19

Purchased

No

Each

315.0000

28

MS27039-08-19

Screw

**

DAS

6

9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

182

m135948

182

ST277

133

m135865

33

m136042

100

28

MS27039-1-19

Purchased

No

Each

123.0000

12

MS27039-1-19

Screw

**

DAS

6

9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

80

m134134

80

ST280

43

m135774

43

12

MS27039-08-24

Purchased

No

Each

281.0000

24

MS27039-08-24

Screw (MS27039-0824)

**

DAS

6

9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

279

124326

279

ST277

2

125654

2

2

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Shop Packet Print

Page 4

QTY		PARTS LIST		PRICE		SPEC.	
NEXT ASSY (S)		APICAL INDUSTRIES					
647.7300		2508 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300					
		LOWER CUTTER ASSY					
GEOGRAPHIC DATA DRAWING NUMBER A-QMAN P-BRavo PARTING APPROVAL DATED COMMENTS		N/E CASE CODE B 07M26 SCALE NONE		DWG. NO. 647.7500		REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS ±.010 3 PLACES DECIMALS ±.005 ANGLES ±.5°		1/8"=1'-0" 1/4"=1'-0" 1/2"=1'-0" 3/4"=1'-0" 1"=1'-0" 1 1/2"=1'-0" 2"=1'-0" 3"=1'-0" 4"=1'-0" 6"=1'-0" 8"=1'-0" 12"=1'-0" 18"=1'-0" 24"=1'-0" 36"=1'-0" 48"=1'-0" 60"=1'-0" 72"=1'-0" 84"=1'-0" 96"=1'-0" 108"=1'-0" 120"=1'-0" 144"=1'-0" 168"=1'-0" 192"=1'-0" 216"=1'-0" 240"=1'-0" 264"=1'-0" 288"=1'-0" 312"=1'-0" 336"=1'-0" 360"=1'-0" 384"=1'-0" 408"=1'-0" 432"=1'-0" 456"=1'-0" 480"=1'-0" 504"=1'-0" 528"=1'-0" 552"=1'-0" 576"=1'-0" 600"=1'-0" 624"=1'-0" 648"=1'-0" 672"=1'-0" 696"=1'-0" 720"=1'-0" 744"=1'-0" 768"=1'-0" 792"=1'-0" 816"=1'-0" 840"=1'-0" 864"=1'-0" 888"=1'-0" 912"=1'-0" 936"=1'-0" 960"=1'-0" 984"=1'-0" 1008"=1'-0" 1032"=1'-0" 1056"=1'-0" 1080"=1'-0" 1104"=1'-0" 1128"=1'-0" 1152"=1'-0" 1176"=1'-0" 1200"=1'-0" 1224"=1'-0" 1248"=1'-0" 1272"=1'-0" 1296"=1'-0" 1320"=1'-0" 1344"=1'-0" 1368"=1'-0" 1392"=1'-0" 1416"=1'-0" 1440"=1'-0" 1464"=1'-0" 1488"=1'-0" 1512"=1'-0" 1536"=1'-0" 1560"=1'-0" 1584"=1'-0" 1608"=1'-0" 1632"=1'-0" 1656"=1'-0" 1680"=1'-0" 1704"=1'-0" 1728"=1'-0" 1752"=1'-0" 1776"=1'-0" 1800"=1'-0" 1824"=1'-0" 1848"=1'-0" 1872"=1'-0" 1896"=1'-0" 1920"=1'-0" 1944"=1'-0" 1968"=1'-0" 1992"=1'-0" 2016"=1'-0" 2040"=1'-0" 2064"=1'-0" 2088"=1'-0" 2112"=1'-0" 2136"=1'-0" 2160"=1'-0" 2184"=1'-0" 2208"=1'-0" 2232"=1'-0" 2256"=1'-0" 2280"=1'-0" 2304"=1'-0" 2328"=1'-0" 2352"=1'-0" 2376"=1'-0" 2400"=1'-0" 2424"=1'-0" 2448"=1'-0" 2472"=1'-0" 2496"=1'-0" 2520"=1'-0" 2544"=1'-0" 2568"=1'-0" 2592"=1'-0" 2616"=1'-0" 2640"=1'-0" 2664"=1'-0" 2688"=1'-0" 2712"=1'-0" 2736"=1'-0" 2760"=1'-0" 2784"=1'-0" 2808"=1'-0" 2832"=1'-0" 2856"=1'-0" 2880"=1'-0" 2904"=1'-0" 2928"=1'-0" 2952"=1'-0" 2976"=1'-0" 3000"=1'-0" 3024"=1'-0" 3048"=1'-0" 3072"=1'-0" 3096"=1'-0" 3120"=1'-0" 3144"=1'-0" 3168"=1'-0" 3192"=1'-0" 3216"=1'-0" 3240"=1'-0" 3264"=1'-0" 3288"=1'-0" 3312"=1'-0" 3336"=1'-0" 3360"=1'-0" 3384"=1'-0" 3408"=1'-0" 3432"=1'-0" 3456"=1'-0" 3480"=1'-0" 3504"=1'-0" 3528"=1'-0" 3552"=1'-0" 3576"=1'-0" 3600"=1'-0" 3624"=1'-0" 3648"=1'-0" 3672"=1'-0" 3696"=1'-0" 3720"=1'-0" 3744"=1'-0" 3768"=1'-0" 3792"=1'-0" 3816"=1'-0" 3840"=1'-0" 3864"=1'-0" 3888"=1'-0" 3912"=1'-0" 3936"=1'-0" 3960"=1'-0" 3984"=1'-0" 4008"=1'-0" 4032"=1'-0" 4056"=1'-0" 4080"=1'-0" 4104"=1'-0" 4128"=1'-0" 4152"=1'-0" 4176"=1'-0" 4200"=1'-0" 4224"=1'-0" 4248"=1'-0" 4272"=1'-0" 4296"=1'-0" 4320"=1'-0" 4344"=1'-0" 4368"=1'-0" 4392"=1'-0" 4416"=1'-0" 4440"=1'-0" 4464"=1'-0" 4488"=1'-0" 4512"=1'-0" 4536"=1'-0" 4560"=1'-0" 4584"=1'-0" 4608"=1'-0" 4632"=1'-0" 4656"=1'-0" 4680"=1'-0" 4704"=1'-0" 4728"=1'-0" 4752"=1'-0" 4776"=1'-0" 4800"=1'-0" 4824"=1'-0" 4848"=1'-0" 4872"=1'-0" 4896"=1'-0" 4920"=1'-0" 4944"=1'-0" 4968"=1'-0" 4992"=1'-0" 5016"=1'-0" 5040"=1'-0" 5064"=1'-0" 5088"=1'-0" 5112"=1'-0" 5136"=1'-0" 5160"=1'-0" 5184"=1'-0" 5208"=1'-0" 5232"=1'-0" 5256"=1'-0" 5280"=1'-0" 5304"=1'-0" 5328"=1'-0" 5352"=1'-0" 5376"=1'-0" 5400"=1'-0" 5424"=1'-0" 5448"=1'-0" 5472"=1'-0" 5496"=1'-0" 5520"=1'-0" 5544"=1'-0" 5568"=1'-0" 5592"=					

1 2 3 4 5 6 7 8

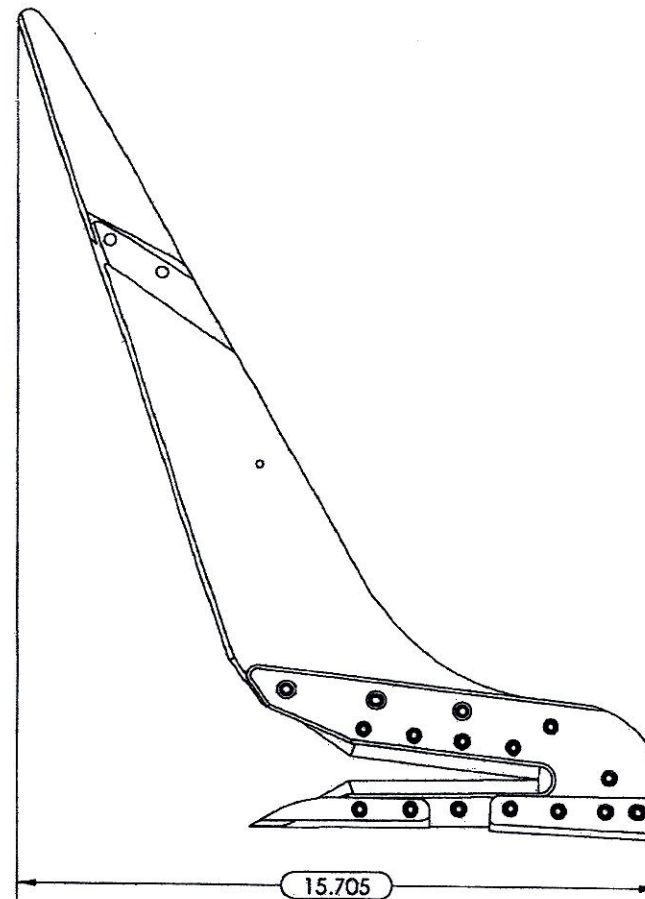
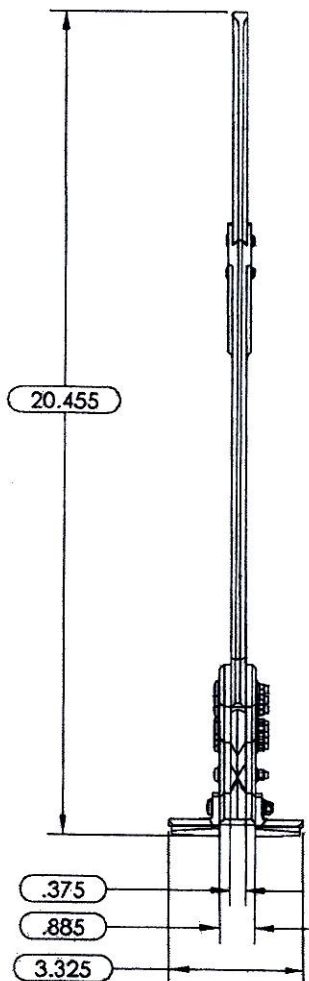
A

B

C

D

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	ORIGINAL DATE 08-04-79	11-24-09	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY A. QUINN	CHECKER P. BRAYO		
	DRAWING APPROVAL P. BRAYO 11-24-09		LOWER CUTTER ASSY	
	CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS .005 3 PLACE DECIMALS .010 ANGLES 2° 3'				
	SIZE B	CAGE CODE 07M26	DWG. NO. 647.7500	REV. A
SCALE NONE				SHEET 2 OF 2